

Date: Friday, 10/13/2006 9:30:38 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 28968	
Estimate Number : 12462	
P.O. Number :	Part Number : D35083
This Issue : 10/13/2006 S.O. No. :	Drawing Number : D3508 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 27711	Material :
Written By :	Due Date : 10/30/2006 Qty: 12 Um: Each
Checked & Approved By : <u>JA 06 10 13</u>	
Comment : Est Rev:A New Issue 06-06-20 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.7707 sf(s)/Unit Total : 9.2484 sf(s)

1010/1025/A21/6aA SHEET

(M1010S20GA)

Batch: M101463

Handwritten: SAD per DH

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3508

Dwg Rev: AProg Rev: Per 1

Handwritten: SAD 06:10:21 12

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Handwritten: JLM 06:10:21

Handwritten: (12)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

Handwritten: 06:10:25 (12)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Form on brake using DT8326 and DT8261 as per Dwg D3508

2-Form joggle as per Dwg D3508 Using DT8158

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 10/13/2006 9:30:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 28968

Part Number: D35083

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 57.03.13

Dart Aerospace Ltd

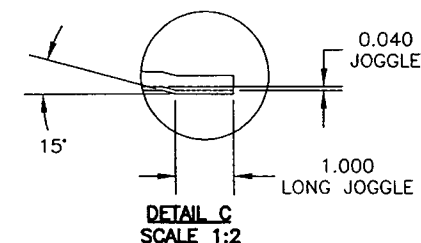
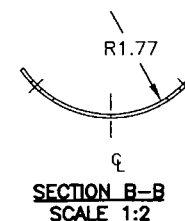
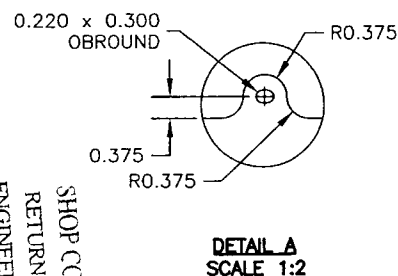
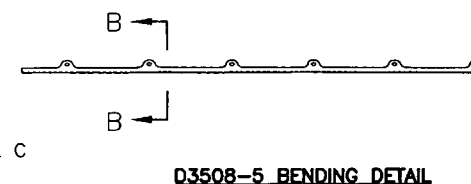
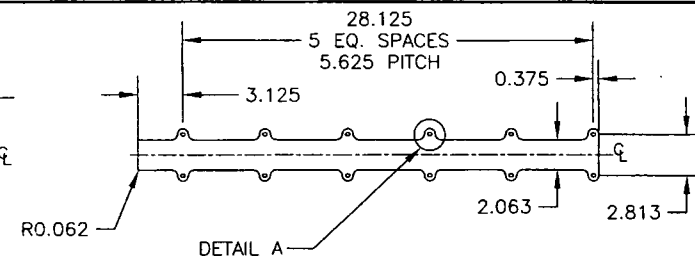
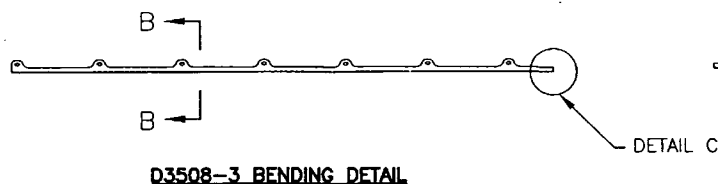
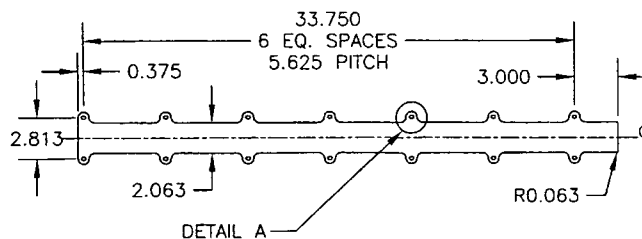
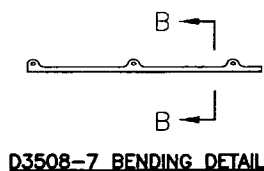
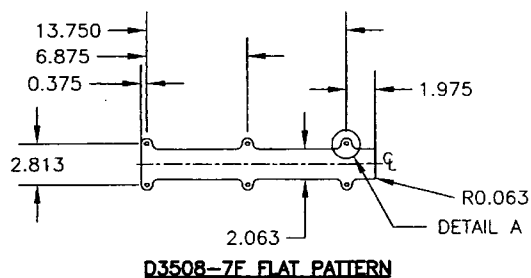
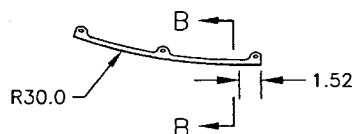
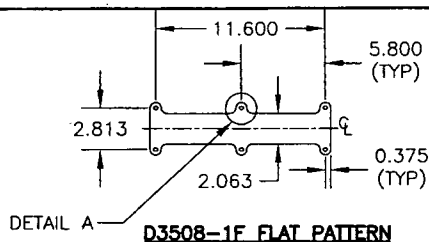
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3508-1/-3/-5/-7 WEARPLATE NOTES

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 20 GAUGE (0.040 THICK) (REF DART MATERIAL SPEC M1010-S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE

NO. 20868
 WORK ORDER
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 ENGINEERING
 RETURN TO
 SHOP COPY

RELEASED
 06-10-02-PA
 FOR ECU #861

A		06.04.21	NEW ISSUE
DESIGN	PH	DRAWN BY	PH
CHECKED	PH	APPROVED	PH
DATE	06.04.21	DRAWING NO.	D3508
		TITLE	WEARPLATE
COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
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		SCALE	1:1

